



DESIGN JH	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED LE	DRAWING NO. D2720	REV. B SHEET 1 OF 2
DATE 98.12.04		TITLE FLOAT TUBE ASSEMBLY	SCALE NTS
A	97.11.19	NEW ISSUE	
B	98.12.04	REDRAWN, ADD TOW RING PROVISIONS	

QTY	Part Number	Description
X	D2720-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2715-041	WEB
2	D2575	AFT CAP
31	D2579	CROSS BOLT SPACER
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
48	AN3-4A	BOLT
48	AN960JD10L	WASHER

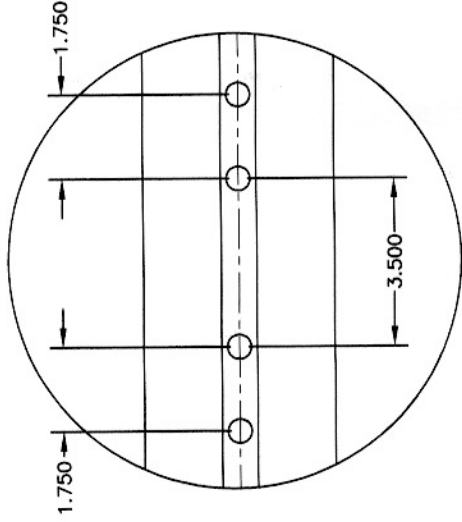
\* CUT EXTRUSION TO LENGTH PER THIS DRAWING

#### GENERAL NOTES:

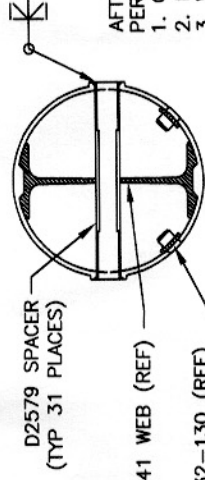
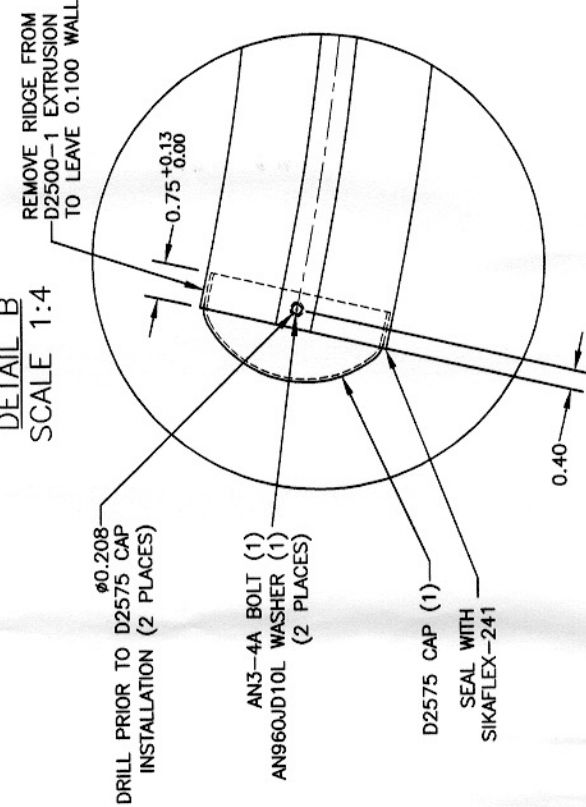
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES \*
- 3) INSERT D2715-041 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. THERE SHOULD BE NO VISIBLE WRINKLES AFTER BENDING. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE STRAIGHT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241/291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2715-041 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

RELEASED  
98.12.15 DS

DETAIL A  
SCALE 1:4



DETAIL B  
SCALE 1:4

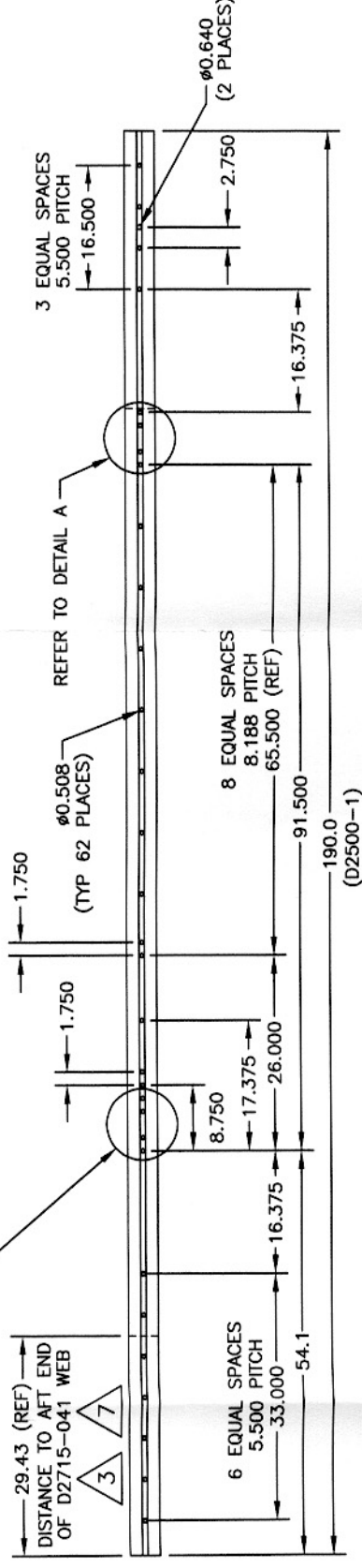


SECTION C-C  
SCALE 1:4

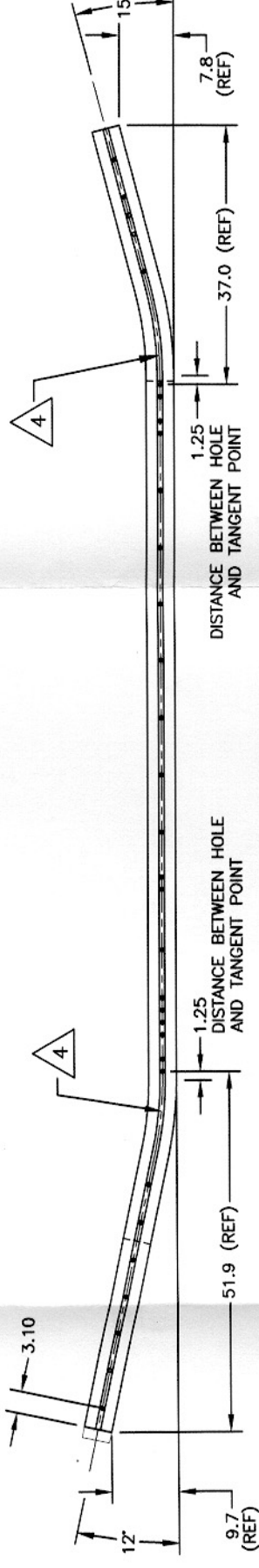
- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR  $\phi 0.508$  HOLES ONLY:
1. CHAMFER HOLE  $0.050 \times 45^\circ$
  2. INSERT D2579 SPACER (31 PLACES)
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE D2579 SPACER TO  $\phi 0.437 \times 1.00$  DEEP

D2720-1 DRILLING DETAIL

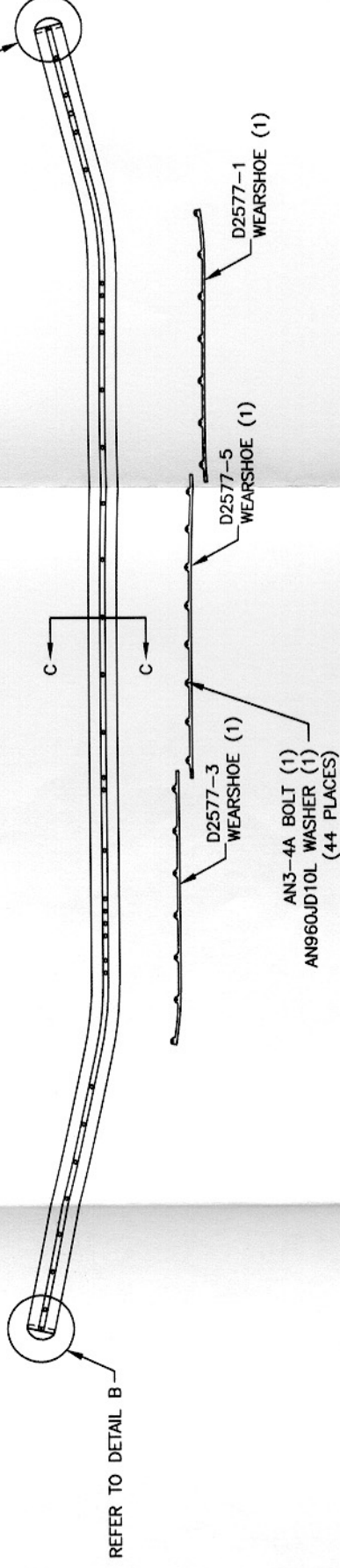
DRILL HOLES ON CENTER-LINE (REMOVED FOR CLARITY)



D2720-1 BENDING AND CUTTING DETAIL



D2720-041 ASSEMBLY DETAIL



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CHECKED	APPROVED	DRAWING NO. D2720
DATE	TITLE	SCALE
98.12.04	FLOAT TUBE ASSEMBLY	1:24